

Work Order ID 127049-2

December-04-14 9:12:58 AM

127049

Page 1

Item ID: D3187-2

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Panel

Start Date: 12/04/14 Start Qty: 3.00

3 2
3

Cust Item ID:

Required Date: 12/08/14 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3187

D

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3187

Dwg Rev: DProg Rev: D

2-Deburr if necessary

DAS

23

9-89

14-12-7

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

TEMPLATE DT3187-1T1

DAS

23

9-89

14-12-7

Work Order ID 127049

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Page 2

Item ID: D3187-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Panel
 Start Date: 12/04/14 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/08/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QCS- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				3	14-12-08		DAS 9 9-89
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00				3	14-12-10		DAS 34 9-89
Hand Finishing									
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:05.								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 9:35.								
						3	14-12-15		DAS 34 9-89

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Page 3

Item ID: D3187-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Panel
 Start Date: 12/04/14 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 12/08/14 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							JAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary as per dwg D3187								
	A/R contact cement Batch: 105623/127394								
	2- transfer holes from spacepod floor to rubber spacer								
170	QC5- Inspect part completeness to step on W/O	0.00							JAS 38 9-89
170									
QC	Memo	0.00							
Quality Control									

DEC 16 2014

FEB 13 2015

FEB 13 1962

1962

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/04/14 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 12/08/14 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

0.00

Packaging

DAS
06
9-89

FEB 10 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 1502-V

ME
15-2-1

Picklist Print

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Page 1

Work Order ID: 127049

127049

Parent Item: D3187-2

D3187-2

Parent Item Name: Floor Panel

Start Date: 12/04/14

Required Date: 12/08/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: C05.04.14 Now a purchased part KJ/JLM
IPP Rev:D Now on Waterjet 07-04-19 JLM
IPP Rev:E Now Powder Coated 07-05-24 JLM
IPP Rev:F 09-01-20 rev.C as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2986-1		Manufactured	No			110	Each	3.0000	1	3			

D2986-1

Rubber Spacer

127615 x 2

**

85 15-02-09

Location	Loc Qty	Loc Code
ST141a	1	
111670	1	
ST518A	2	
125349	2	

M6061T6S.050

Purchased

No

160

sf

168.5500

7.43

✕

**

32

DAS

23

9-89

14-12-7

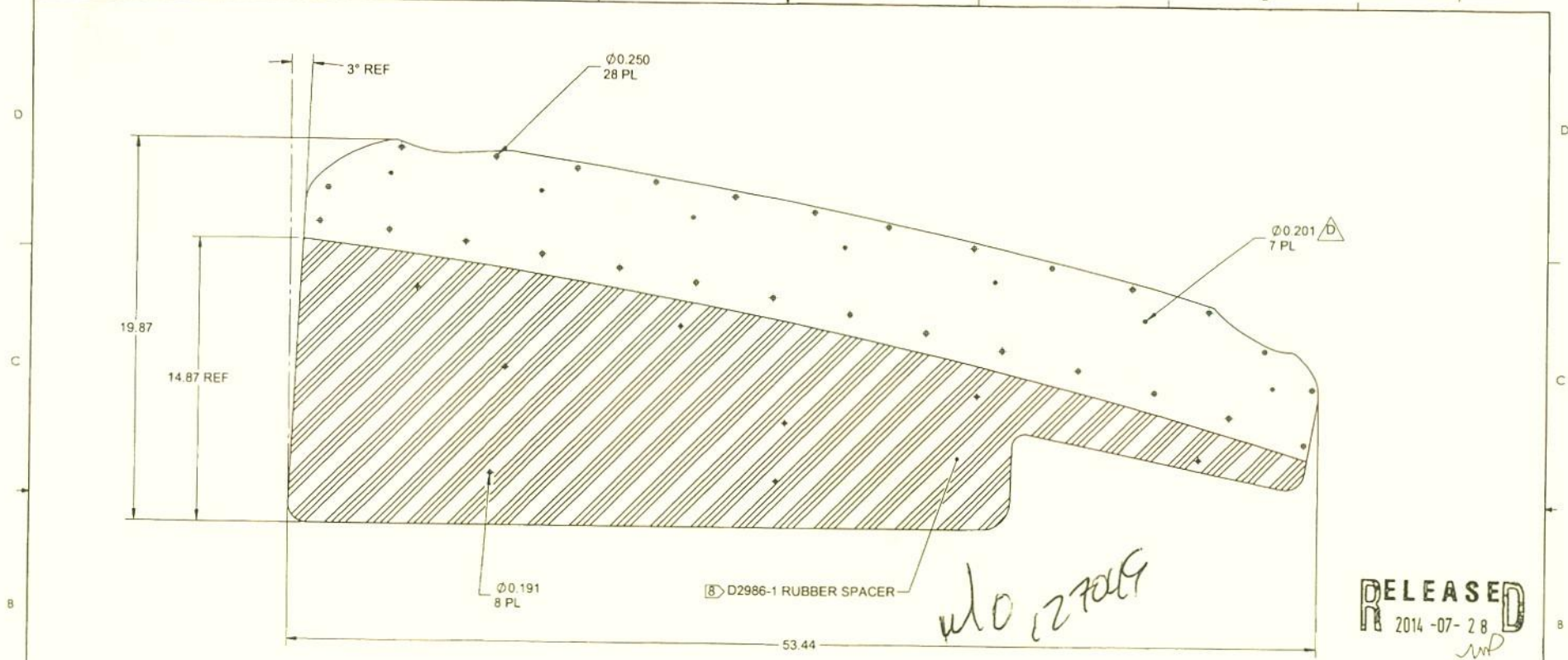
M6061T6S 050

6061-T6 .050 Sheet

Location	Loc Qty	Loc Code
MAT021	168.55	
123293	15.5	
125636	94.85	
M128408	58.2	

125408

8 7 6 5 4 3 2 1



D3187-1 SPACEPOD FLOOR LH
(MAKE FROM D3187-1F)

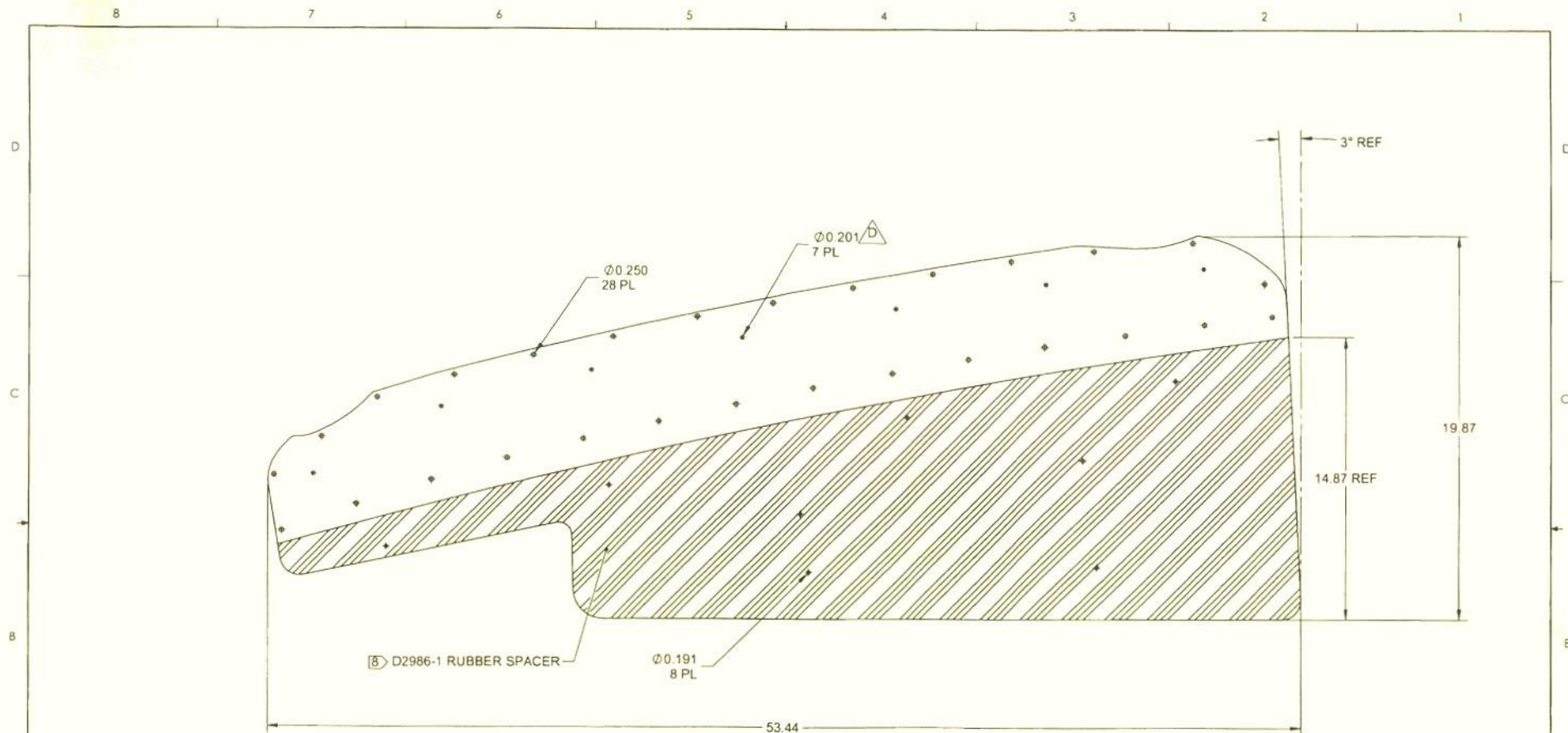
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC. M6061T6S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" PER QSI 044 6.1
- 7) WEIGHT: 4.2 lbs
- 8) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT
- 9) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D3187-1F-D.DXF".

D	ADD HOLES FOR D-RING INSTALLATION, 7 PL, ADD NOTE #9 (REASON: PAR 14-349)	DB	14 06 19
C	REDRAWN TO CURRENT STANDARDS, TRANSFERRED TO B-SIZE FORMAT, ADDED SHEET 2, CREATED DETAIL FOR D3187-2, REVISED SHEET 1 NOTES, REASON CLARIFIED DRAWINGS FOR D3187-1/2	MB	09 01 05
B	CHANGE SHAPE	CP	03 05 16
A	NEW ISSUE	CP	03 03 13
REV	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3187	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACEPOD FLOOR	NTS
DATE	14.06.19	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR SERVICE OR COMMERCIALIZED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1



D3187-2 SPACEPOD FLOOR RH
(MAKE FROM D3187-1F)

RELEASED
2014-07-28

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" PER QSI 044 6.1
- 7) WEIGHT: 4.2 lbs
- 8) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT
- 9) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D3187-1F-D.DXF".

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3187	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACEPOD FLOOR	NTS
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